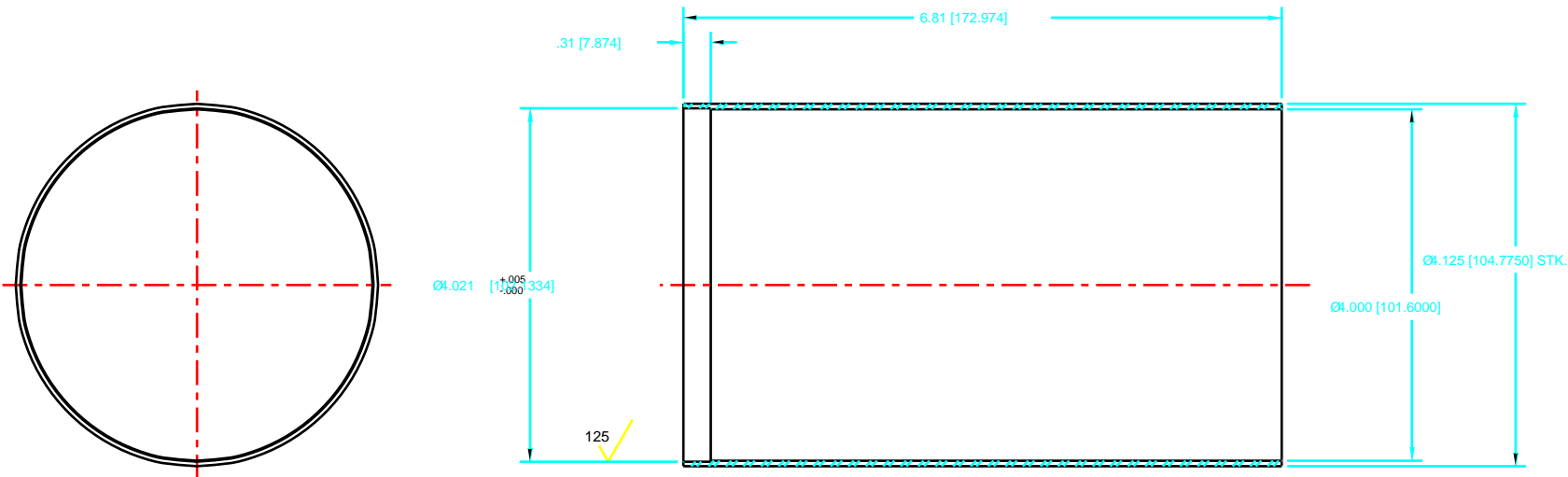


(Ø)

PLOT SCALE: 1=1

DWG. SCALE: 1



NOTES:

1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV).
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE COMPONENT NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING, AND DRY NITROGEN BLOWDOWN. THE CHAMBER VACUUM SIDE SURFACE ROUGHNESS SHALL BE BETTER THAN 63 MICROINCH RMS AFTER ELECTROPOLISHING.
4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
5. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK.
6. ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY.

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .X - .015 .XX - .010 .XXX - .005 ANGULAR - .25 SURFACE ROUGHNESS 250 REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5		LOG NUMBER A18061 DRAWN BY R. KRAKORA CHECKED BY J. CHANG DESIGNER R. KRAKORA RESPONSIBLE ENGINEER J. CHANG	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY CHIEF DESIGN ENGINEER D. SHU GP LEADER T. M. KUZAY PROJECT MGR. APPROVED/RELEASED	DATE 3/94 6/8/94 3/94 6/8/94
SYM		CHANGE DESCRIPTION	BY	CHKD DATE
REVISIONS				
DO NOT SCALE DRAWING				
MATERIAL SST 304 Ø4.12 x .062 WALL		SCALE 1:1 SHEET 1 of 1	SIZE C	DRAWING NUMBER P41050914097-330003-00

ADVANCED PHOTON SOURCE
B7 BM BEAM MIS-STEERING
SAFETY MONITOR
LONG BELLOW TUBE